












Date: Friday, 11/11/2005 2:45:24 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR WINDOW
Job Number	: 24752	Part Number	: D32121
Estimate Number	: 10457	Drawing Number	: D3212 REV A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/11/2005 S.O. No. : N/A	Drawing Revision	: A
Prsht Rev.	: NC	Material	: Multiples of 4
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 11/30/2005
Previous Run	: N/A	Qty:	10 Um: Each
Written By	: See comment below		
Checked & Approved By	: See comment below		
Comment	: Est Rev: A New Issue 05-11-09 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	MLEXANS125	1/8" Lexan Sheet	
			
Comment: Qty.: 1.0232 sf(s)/Unit Total : 10.2323 sf(s) Material: 0.125" Polycarbonate (M-LEXAN-S.125) Identify as D3212-1 Batch: <u>M18474</u>			
2.0	SHEAR	SHEAR	
			
Comment: SHEAR Cut blanks: 15.250" x 9.200" (+0.000/-0.010)			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3212-1 as per Folio FA349 and Dwg D3212Stack of 4			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			

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Drawing Name: FLOOR WINDOW

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

SAD/12/12/05/ 11

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05-12-13

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 46

10 05/12/19 (10)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

545 05/12/21 (10)

05/12/20

Job Completion



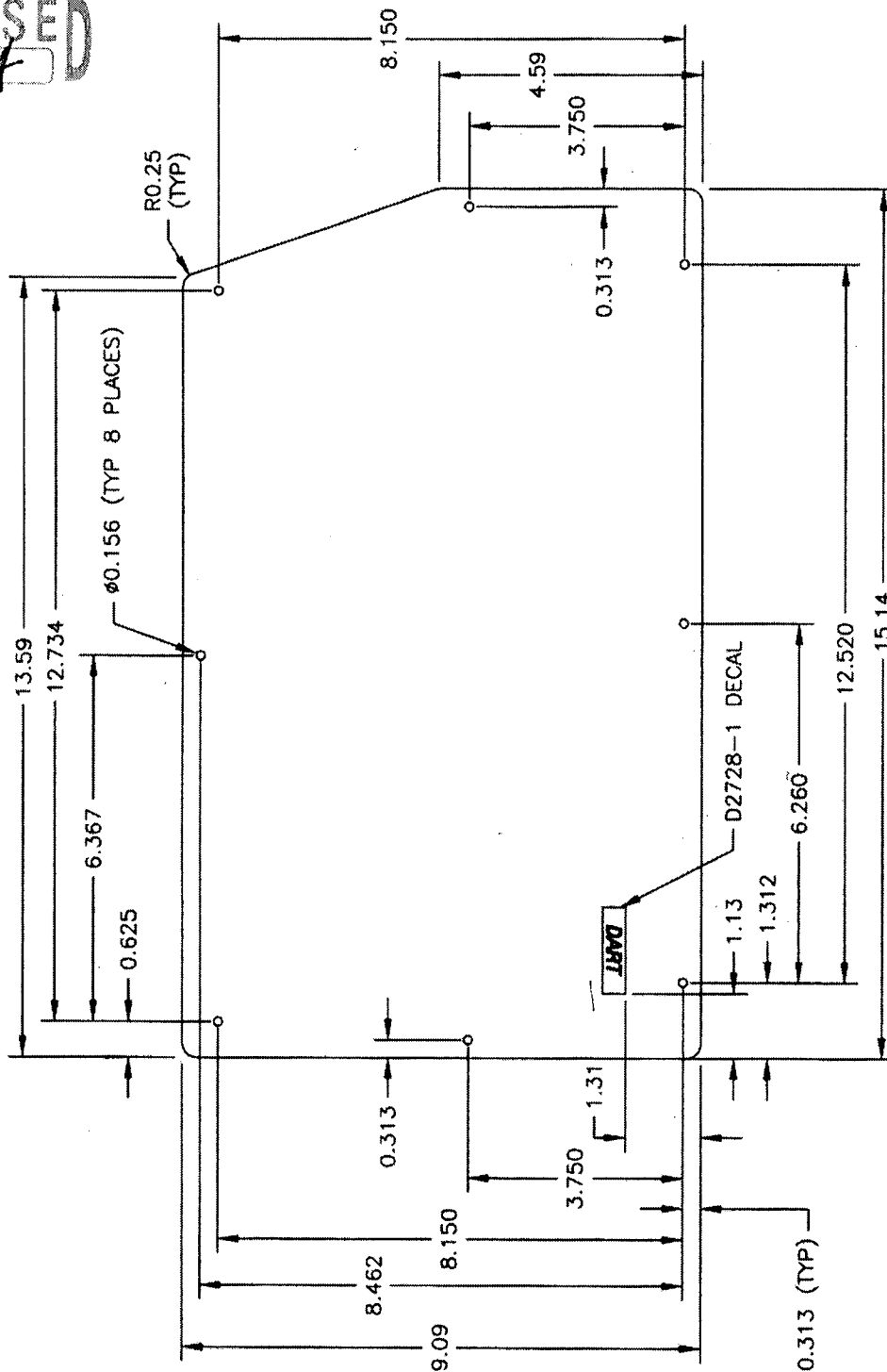
PTD
Last p4-



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3212	REV. A SHEET 1 OF 1
DATE 03.09.03		TITLE FLOOR WINDOW	SCALE 1:3
A	03.09.03	NEW ISSUE	

RELEASED
03.09.03

D3212-1 FLOOR WINDOW
MACHINE PER DRAWING FILE "D3212-A1.DWG"
CHECK WITH TEMPLATE D3212-1T1
DIMENSIONS ARE FOR REFERENCE ONLY
MATERIAL: 1/8" CLEAR POLYCARBONATE
TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED



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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 10, 2005
07:04 am

Work Order No	: 0024752	Department Code:	
Project Name	: D3212-1	Burden Flags	: NNNNNNNN
Project For	: WK547	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3212-1	Invoice Number	:
Description	: Floor Window	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-09-05		
Est Finish Date	: 11-24-05	Est. Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05/12/19	6.	D 2728-1 B 24215 / gets installed in windows as per Dwg. 03212. + part windows in plastic wrap	SAP [Signature]	19/12/05	10	[Signature]	2 05-12-19

Part No: D3212 PAR #: _____ Fault Category: Production / machined ^{Parts} NCR: Yes No DQA: [Signature] Date: 05/12/20
 QA: N/C Closed: [Signature] Date: 05.12.20

NCR: <u>24572</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/11	3.0	one part scrap sleer left a .1ip on the side THAT located at the base pin.	[Signature]	Scrap and Destroy (no Repair) check part before machining	En 05/12/11	2 05-12-13	[Signature]	2 05-12-13
05-12-13	7.0	1 window was found w. th a hole at .220" instead of .156". was done on HAAS.	[Signature]	Scrap & destroy	2 05-12-13	2 05-12-13	[Signature]	2 05-12-13

NOTE: Date & initial all entries